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D3220-041

Job Sheet 208589



Part No: D3220-041

Job Qty: 4 pcs

Part Name: Doubler Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/25/20

Job Tracking No:

Due Date: 3/31/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A New Issue 05-11-06 JLM IPP: B 06.11.15 waterjet EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	4 pcs		3/30/20	0.10	0.43	Waterjet - Flow		TF March, 25, 2020
110	QC 2	4 pcs		3/30/20	0.00	0.00	QC 2 - 1		
Rush!!!							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		TF March, 25, 2020
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
QC 2 - 63									
QC 2 - 8									
QC 2 - 66									
QC 2 - 64									
							Plex 3/25/20 12:20 PM Dart.lajeunesse.mar		

120	QC 8	4 pcs	3/30/20	0.00 0.00	QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
					QC 8 - 66	
130	Small Fab - 2 - B4B	4 pcs	3/30/20	0.00 0.28	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
					Small Fab - 9 - B4B	
					Small Fab - Various 1 - B4B	
140	QC 5	4 pcs	3/30/20	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	

DAS
MAR 26 2020 40
9-89

DAS
58 MAR 26 2020
9-89

					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	MAD 26 2020
					QC 5 - 61	DAS 40 9-89
					QC 5 - 81	
					QC 5 - 9	
150 Handfinish - 1-1 Chemical-B4B	4 pcs	3/30/20	0.00 0.30		Handfinish - 1 - 1 - B4B	BEB 20-03-26
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
160 QC 3	4 pcs	3/30/20	0.00 0.00		QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	DAS 58 MAR 26 2020
					QC 3 - 59	9-89
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
					QC 3 - 82	
					QC 3 - 87	
170 Small Fab - 3 - B4B	4 pcs	3/31/20	0.00 0.36		Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	

3/25/2020

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DAS
58 MAR 26 2020
9-89

180 QC 5	4 pcs	3/31/20	0.00 0.00	Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
				Small Fab - Various 1 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
190 Packaging 3-1 - Stock - B4B	4 pcs ✓	3/31/20	0.00 0.00	QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	MAR 26 2020
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B ✓	ST48SDAS MAR 26 2020
				Packaging 3 - 4 - B4B	80
				Packaging 3 - 5 - B4B	9-89
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	

DAS
82
9-89

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3/25/2020

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				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
200 QC 21 - SA	4 ✓ pcs	3/31/20	0.00 0.00	QC 21 - SA - 21 ✓	ST 485
				QC 21 - SA - 70	DAS
				QC 21 - SA - 53	21

Part Op 100 - 1-Cut D3220-1 as per Dwg D3220 Dwg Rev: B

Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)
 120 - (QC8- Inspect parts - second check)
 130 - (Small Fab) 1-Deburr 2-C'sink D3220-1 as per Dwg D3220
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - (Chemical Conversion Coat per QSI005 4.1)
 160 - (QC3- Inspect Part Finish)
 170 - (Small Fab) Assemble D3220-041 doubler as per Dwg D3220
 180 - (QC5- Inspect part completeness to step on W/O)
 190 - (Identify as per dwg & Stock Location: _____)
 200 - (QC21- Final Inspection - Work Order Release)

MAR 26 2020

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.050	2024-T3 .050 Sheet	2.7704 sf (.6926 ea)	100-Waterjet - Flow - 1	5237392
MS20426AD3-3	Rivet	32 Ea (8 ea)	170-Small Fab - 3 - B4B	5217900
MS21059L4	Nutplate	16 Ea (4 ea)	170-Small Fab - 3 - B4B	5237863

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.050	3	81	0
170-Small Fab - 3 - B4B	MS20426AD3-3	32	4,625	0
	MS21059L4	16	74	0

Part Specifications	
Specifications could not be found.	

GA007
ST301

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DART AEROSPACE LTD		Work Order: 208589
Description: Doubler		Part Number: D3220-1
Inspection Dwg: D3220	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.50	+/-0.030	5.50	/		Tape	
14.25	+/-0.030	14.25	/		Caliper	
R0.50	+/-0.030	0.50	/			
7.00	+/-0.030	7.00	/			
7.000	+/-0.005	7.001	/			
1.50	+/-0.030	1.51	/			
1.000	+/-0.005	1.004	/			
0.500	+/-0.005	0.502	/			
1.000	+/-0.005	0.999	/			
0.316	+0.005/-0.000	0.317	/			
0.098	+0.005/-0.000	0.099	/			
0.050 thick	+/-0.005	0.053	/			
Grain Direction	N/A					

Measured by: TF	Audited by: DAS 40	Prototype Approval:	N/A
Date: March 25, 2020	Date: MAR 26 2020	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.27	New Issue P/O D3220-041	KJ/RF	
B	10.02.02	Dwg Rev updated	KJ	

159

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

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Container No: S266443



Part: D3220-041

Job No: 208589

Serial No/Batch: S266443

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/25/20